Work Orde				*10	5954*							Page 1
Item ID: Revision ID: Item Name:	D3121-23 Bearing	,		Accept	*N900	040	100	ገ*	Setup	Start Stop	*N.	S1* S2*
Start Date: Required Date: Reference:	8/27/2013	Start Qty: 200.00 Req'd Qty: 200.00	*200 *200		Cust Item Customer:				_	0: 4	I VI	.J/
Approvals:	Process Pla	an: <u>C</u>	Date: 13/08	Tooling:	D	ate:			Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):		ate:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Re		Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr	· 			-		.		·		
D3121	Rev	Ę					·					
*100 *100* Purchasing Purchasing		PURCHASING Memo Issue P/O:c SKF P/N: 619	2 1093 Bearing a 100-2Z or KML P/N: 69	0.00 0.00 s per Dwg D3121Possib 00-ZZMaterial release r	ole Supplier: note is required			_G	13.	<u>108</u> k	, 2_7	<u>200</u>
110		Receive & Inspect for Dan	nage & Mat'l Certs	0.00						12/1		(2/0
110 Packaging Packaging		Memo Ensure Mater	ial Release Note is attac	0.00 ched				-/	_ 4	JI	<u>-28</u>	
*120 *120* QC		QC6- Inspect dimensions Memo		0.00	S 28			<u>2a</u>	<u> </u>			
Quality Control		Inspect diime	nsions as per Dwg D312	21 and attached certfica	ition Dwg Rev			4				

			DQA:
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	

		, 110				Work On Delic No.					QA Closed:	Dat	e:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	-					Rework Scrap Use-as-is]		Skid-tube Machining	Crosstube Small Fab Finishing	ł	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	V o					Work Order Update]		Large Fab	Composite		Supplier	
Root	1				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		,		:					-				
Equip/Tooling													
Operator	Ш												
Material	Ш											-	
Setup	Ш											1	
Other	Ш												
Process	Ш												
Supplier				!			1						
Training	Ш			<u> </u>									
Unapproved					_						.		<u> </u>
						F	AUL	T CATE	GORY				
Landi	ng G	iear			_	General	_			<u></u>	7		_
		Bending			<u> </u>	Bend	Ш	Grain		ļ	Ovalized		Pressure/Forced
	Ш	Centre No	t Concer	ntric to	o/s	BOM/Route	\sqcup	Hardwa			Over/Under	F	Temperature/Cure
		Cracks				Broken/Damaged		i	on Incomplete	_	Part Incorre		Weld
	-	Crushed/0	Crimped			Burrs		1	ions incomplete/	'Unclear	Part Lost/Mi	· ·	Wrong Stock Pulled
	Ш	Cuffs				Contamination		Mainte			Part Moved		
	Ц	Heat Trea	t		<u> </u>	Countersink	\vdash	Mislabe		<u> </u>	Positioned V		-
	-	Inspection		Tube	L	Cut Too Short		Misread	t .	L_	Power Loss/	'Surge	Other
	Ш	Ripples in			<u> </u>	Drill Holes	<u> </u>	Offset					
	\square	Torque W	aves in E	xtrusio	n L	Drawing		4	Calibration			<u> </u>	<u></u> .
	Ш	Turning S	equence			Finish		Out of S	Sequence			,	
	1	Wave/Tw	ist in Tub	oe .	1	Folio		Outside	Dimensions				

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord			•	*105	954*	Page 2					
Item ID: Revision ID: Item Name:	D3121-23 Bearing			Accept	*N900		100)* :	Setup Sta	1.71	S1* S2*
Start Date: Required Date: Reference:	8/27/2013 8/29/2013	Start Qty: 200.00 Req'd Qty: 200.00	*20 *20	• •	Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling: _	D:	ate:		I	Run Sta		IR1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	["] *N	IR2*
Sequence ID/ Work Center I	D	Operation Description Identify as per dwg & Stor	ck Location: 5:72	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging		Memo		0.00					173	Js.	- 600
140		OC21- Final Inspection -	Work Order Release	0.00					13	lala	49

0.00

Memo

*14**0***

Quality Control

Al Serge

												DQA:	Da	ite:	
NCR: Ye	es / !	No					WORK ORDER NON-C	10:	NFORM	MANCE / UPI	DATE	QA Closed:	 Da	ıte:	
Work Orde	r:						DISPOSITION				AGAINST D	EPARTMENT	=		
Part No	0						Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	- 1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root Cause	Da	te	Step	Qty	Desc		tion of work order update r Non-conformance		nitial ief Eng		ion ription	Sign & Date	Verificatio	n	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining napproved															
	-						F	AUL	T CATE	GORY					
Landin	g Gear	•••				_	General	HUL	I CATE	JONI					
- - - - - - -	Benc Cent Crac Crus Cuffs Heat Inspo Ripp	re Not ss ned/Cr Treat ection es in E	imped Strip in Bend ves in E	extrusio			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing Finish		Instruct Mainte Mislabe Misread Offset Out of (on incomplete ions incomplete/l inance iled	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Wrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Į.	jiurn	mg 260	quence				L1111211		logram 3	pequence					

Outside Dimensions

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Wave/Twist in Tube

Folio

Picklist Print

Tuesday, August 27, 2013 1:59:15 PM

Work Order ID:

105954

Parent Item:

D3121-23

Parent Item Name:

Bearing

Start Date: 8/27/2013

Required Date: 8/29/2013

Start Qty: 200.00

Required Qty: 200.00

Comments:

IPP A: 04.02.19

New Issue KJ/DS

IPP ReviR FCN 1060 07-11-12 DD verified by FC

	ECN ECN	1000 07-11-12		micu by.LC						·	·		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6900ZZ Bearing		Purchased	No			100	Each	0.0000	1	200	1-1:	3/8/2	200

Page 1

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UP	DATE			
								<u> </u>	QA Closed:	Date:	
Work Orde	:r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N	lo				Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	iption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling Operator Material etup Other Process Supplier Training											
		•	•		F	AULT CATI	GORY		<u> </u>		
Landir	ng Gear				General				_		
	Cracks Crushed Cuffs Heat Tro	Not Conce //Crimped eat on Strip in		D/S	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short	Instruc Maint Mislab Misrea	tion Incomplete tions Incomplete/ enance eled ad	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples	ın Bend			Drill Holes	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

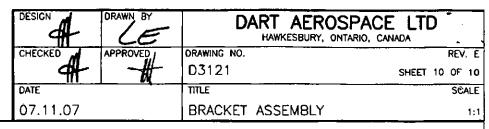
Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G





D3121-21 BOLT (SCALE 1:1)

NONE

4) ALL DIMENSIONS ARE IN INCHES

OTHERWISE NOTED

1) MATERIAL: AISI 303 SS HEX, ANNEALED

TAP 10-32

UNF-3A

- 0.050 TO 0.060

0.080

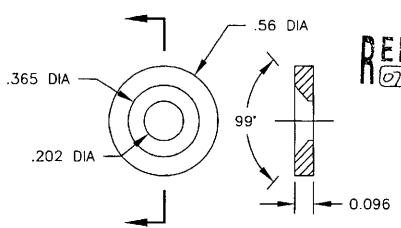
(REF DART SPEC. M303H0.500)

3) TOLERANCES ARE PER DART QSI 018 UNLESS

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

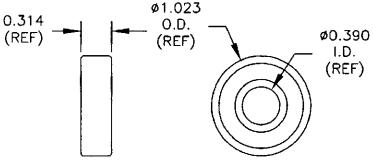
0.375

FINISH:



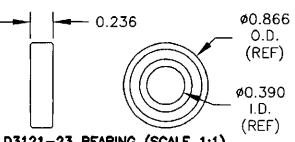
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N 832-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



<u> 03121--19 BEARING (SCALE 1:1)</u>

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



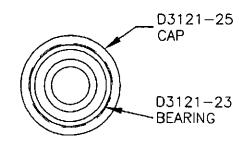
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- ARE, IN INCHES DIMENSIONS

0.315 0.230±0.001 Ɗ\1.000 0.838 0.865 ± 0.002 ±0.001 R0.063

D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES



R0.010 -

D3121-241 BEARING ASSEBLY (SCALE 1:1)

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CX13/08/27

W10: 105954

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										DQA:	Date	
NCR: Y	es / No				WORK ORDER NON-	CONF	ORM	ANCE / UPI	DATE	OA Chanada	Data	
		 -	_		T	_				QA Closed:	Date	<u>. </u>
Work Orde	r.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIK OIGE					Rework	7 l	Sk	kid-tube	Crosstube	7	Water Jet	Engineering
Part N	0.				Scrap	1		chining	Small Fab	Pro	d. Eng. Coor.	Quality
			_		Use-as-is	 _T	hermot	forming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo		<u>-:</u>		Work Order Update]	La	irge Fab	Composite		Supplier	
Root	1	<u> </u>		Descri	ption of work order update	Initi	ial	Act		Sign &	<u> </u>	T
Cause	Date	Step	Qty		or Non-conformance	Chief			ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator	7	ł										
Material []									
Setup [
Other [į						
Process [] [į						
Supplier						1						
Fraining [1					1	
Unapproved												<u> </u>
						FAULT C	ATEGO	DRY				
Landir	ng Gear			_	General				_	—	_	- 1
ļ	Bending				Bend	∭Gr	ain		L	Ovalized	<u> </u>	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	На	irdware		<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	—		Incomplete	_	Part Incorre	<u> </u>	Weld
	Crushed/	Crimped		<u> </u>	Burrs	—		ns Incomplete/L	Jnclear	Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	—	aintena		<u> </u> _	Part Moved		
	Heat Trea			<u> </u>	Countersink	\vdash	islabeled	t	L	Positioned V	_	¬
	Inspectio	n Strip in	Tube	L	Cut Too Short	\vdash	isread		L	Power Loss/	Surge	Other
į	Ripples in	Bend		L	Drill Holes	—	fset					·
	Torque W	Vaves in E	Extrusion	` <u> </u>	Drawing	-		ibration				
	Turning S				Finish	_	ut of Seq	•				
	Wave/Tw	vist in Tul	be		Folio	Ou	utside Di	imensions				



Dart Aerospace Ltd. 4270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO21093

Purchase Order Date 8/27/2013 PO Print Date 8/27/2013

Page Number 1 of 1

Order From:

MAIN INDUSTRIAL SALES LTD.

1475, TESSIER

HAWKESBURY, ON K6A 3S6

 $\mathsf{C}\mathsf{A}$

VC-MAI001

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA

FARD

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

613 632 3595

Yours ppd

Buyer

Chantal Lavoie

Customer POID
Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxablc Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6900ZZ	Bearing	8/29/2013		200.00	\$1.62	\$324.00
	-		Yes		Each		
			8/29/2013				
J	AS PER DWG D3121 REV. I B105954 SUPPLIER SKF P/N:61900-2		•				

Line Total:

\$324.00

PO Total:

\$324.00

(4)

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer. No substitution or deviation without consent.

Certificate of Conformity or Material Certification required YES

PST# 6122-5207

1

Change Nbr:

Change Date:

8/27/2013

e: 8/27

•		
a		

MAIN INDUSTRIAL SALES LTD.

1475 TESSIER ST.

HAWKESBURY ON K6A 3S6

Phone: (613) 632-3595 Ext. Fax: (613) 632-0262

sales@mainindustrialsales.com

Packing Slip : DATE August 28, 2013

NUMBER 0000165339 **CUSTOMER NO. DART**

BILL TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A:1K7 SHIP TO:

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7

(613) 632-5200 Ext.

(613) 632-5200 Ext.

P.O. NUMBER	SALE	SPERSON	ORDER	DATE	REQ. DA	TE ORDE	R NUMBER
21093		EB	28-Aug	-13		00	00165339
F.O.B.		SHIP VIA			1	ERMS	
F.O.B. value		OUR TRUCK / LOCAL			NE	T 30 DAYS	
PART NUMBER						QUANTITY	
DESCRIPTION		LOCATION	U	OM	REQ.	SHIPPED	B.O.
(0-69002ZKML	•	6D6	EA		200	200	
KML BALL BEARING	<i>y</i>						
YOUR PART #: 6900ZZ		•					
·	•	*					
			1				
	•						

	*			
		·		